

Work Order ID 59154-2



Page 1

Thursday, May 27, 2010 9:22:12 AM

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 5/27/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-5-27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536  
2-Debur

SAD 10-05-28

10

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Solator

40

120



Weld per dwg A/R S.S. rod Batch 4115520  
Small Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

M108160

10/06/05

EL 10-6-22

46

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Stop



Start Date: 5/27/2010 Start Qty: 10.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*4* *10.06.23*  
*PD 10.06.23*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*5 10/6/23*

*(46)*

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*11/12/588*  
START TIME: *8:30*  
OVEN TEMPERATURE: *320°*  
FINISH TIME: *9:00*

*6* *bl 10-6-24.*

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Item ID: D2530	Accept		Setup	Start	
Revision ID:			Stop		
Item Name: Handle Weldment					
Start Date: 5/27/2010	Start Qty: 10.00				
Required Date: 6/4/2010	Req'd Qty: 10.00				
Reference:					
			Cust Item ID:		
			Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10	06	24	(6)
170 	Identify as per dwg & Stock Location: <u>506</u>	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

*Per 6/25*  
*6/25*  
*6/25*

# Picklist Print

Thursday, May 27, 2010 9:22:16 AM

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Work Order ID: 59154



Parent Item: D2530



Parent Item Name: Handle Weldment

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	108.1489	2.9145	30.67895			



304 RD Tube .750 x .049W



SAD 10-05-2E

## Location

## Loc Qty

## Loc Code

MAT

80.2854

108498

0

114482

80.2854

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

30.67895

D2534



Lock Plate

Manufactured

No

120

Each

9.0000

2

20



10/06/03

## Location

## Loc Qty

## Loc Code

WA

9

58332

9

8x

59871

12

10-6-23



**DART**

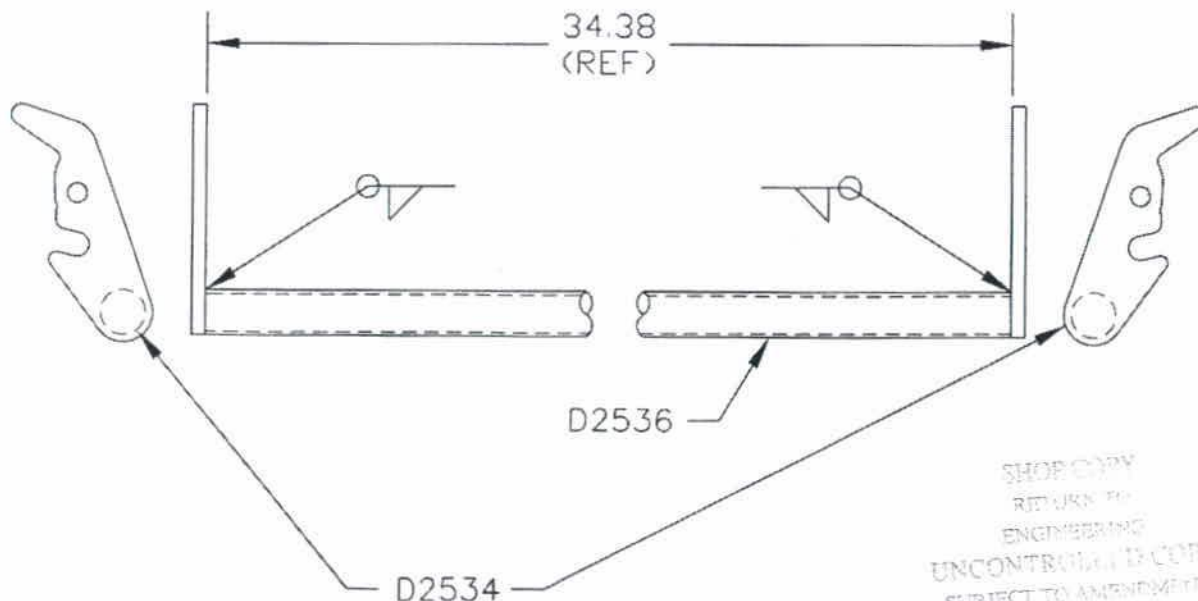
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

## PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 99154

*12/10-5-27*D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED